

Date: Tuesday, 23/12/2008 1:23:21 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HANDLE WELDMENT
Job Number :	44310		
Estimate Number :	12050		
P.O. Number :		Part Number :	D3355047
This Issue :	23/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3355 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	34636	Drawing Revision :	B
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	30/01/2009
Written By :			Qty: 4 ea
Checked & Approved By :			Um: 2 Each
Comment :	est rev A 06.01.20 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D33555	Medium Tubing
-----	--------	---------------



Comment: Qty: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

pick:
Qty Part number Description Batch
1 D3355-5 medium tubing B44252

EL 9-1-8 x4

2.0	D33557	Small Tubing
-----	--------	--------------



Comment: Qty: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

pick:
Qty Part number Description Batch
1 D3355-7 small tubing B34647

EL 9-1-8-x4

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg

EL 9-1-8 x4

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

09-01-08

(x4)

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

09/01/08 (x4)

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 44310

Part Number: D3355047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 18052



(4x)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:50
320°F
1:20

M-L 09/01/09

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M 09.01.10 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(4x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 488

9/1/12

200

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/12 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-12

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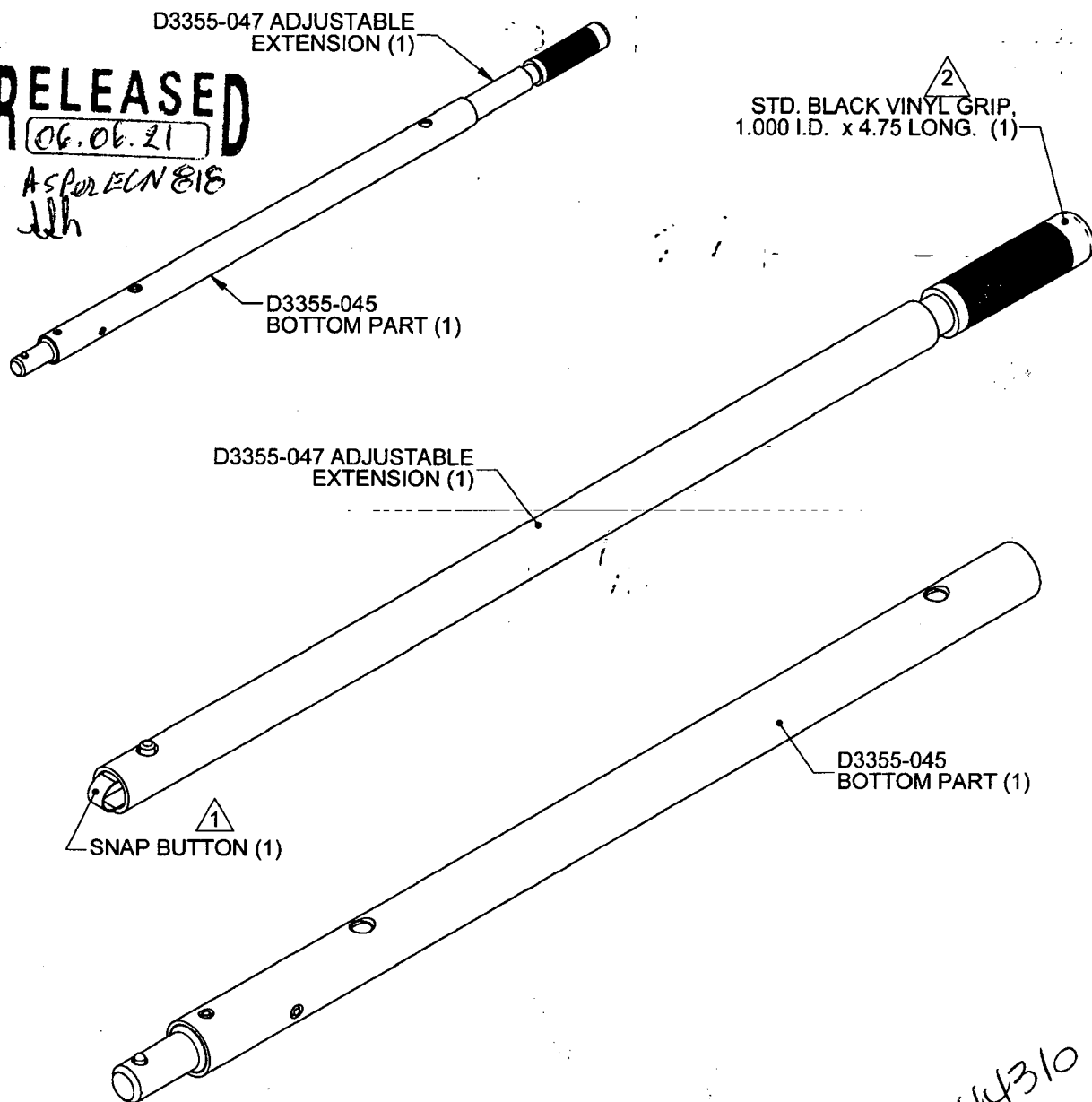
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3355	REV. B SHEET 1 OF 6
DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	

RELEASED
06.06.21

AS PER ECN 818
[Signature]



D3355-041 HANDLE ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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44310

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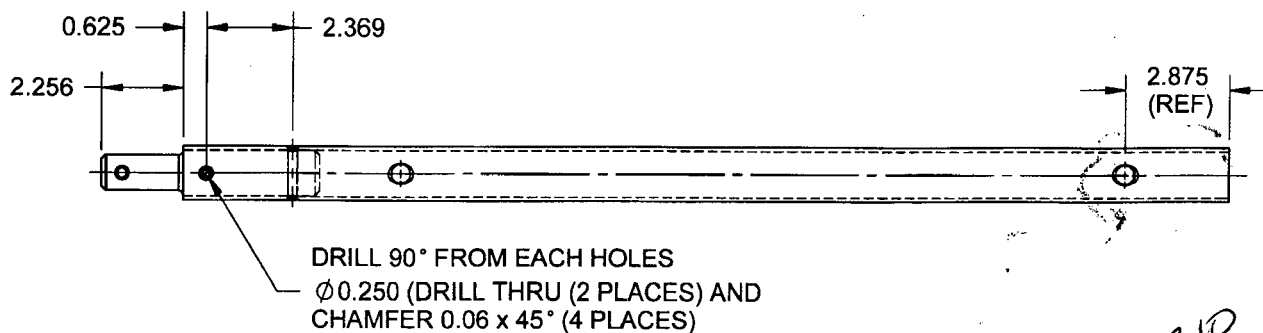
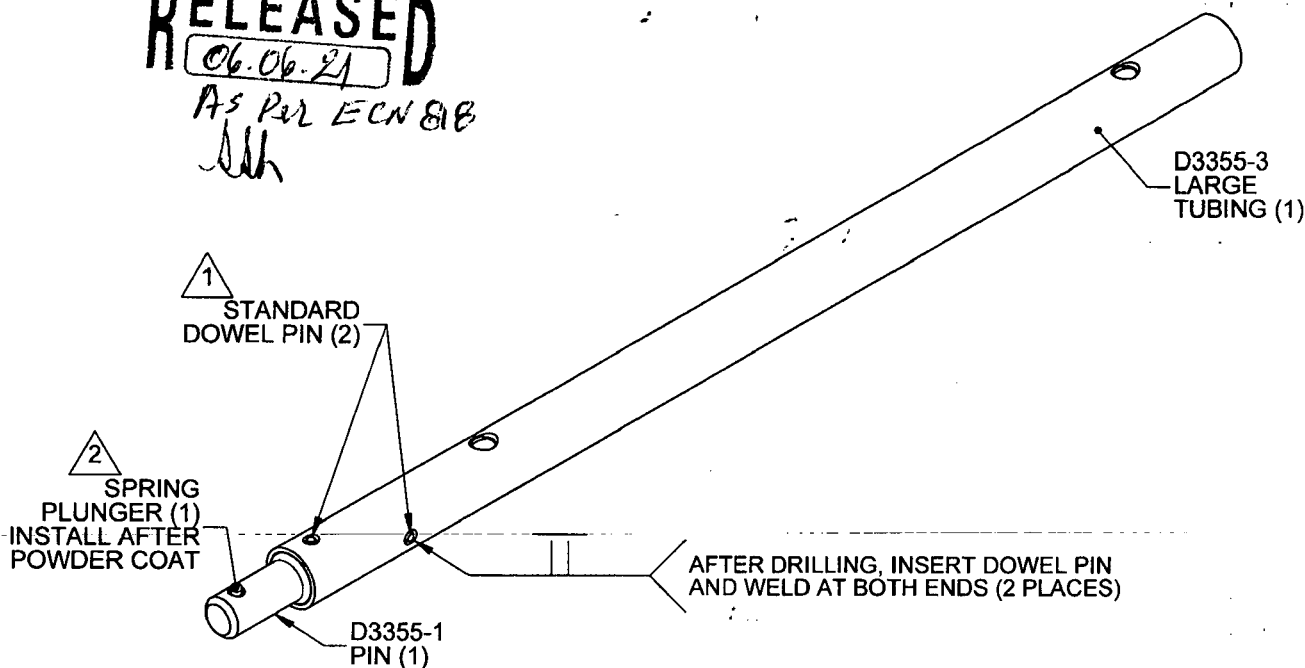


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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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D3355-045 BOTTOM PART

NOTES:

- 1) STEEL STANDARD GROUND DOWEL PIN, $\phi 0.250 \times 1.50$ LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

B

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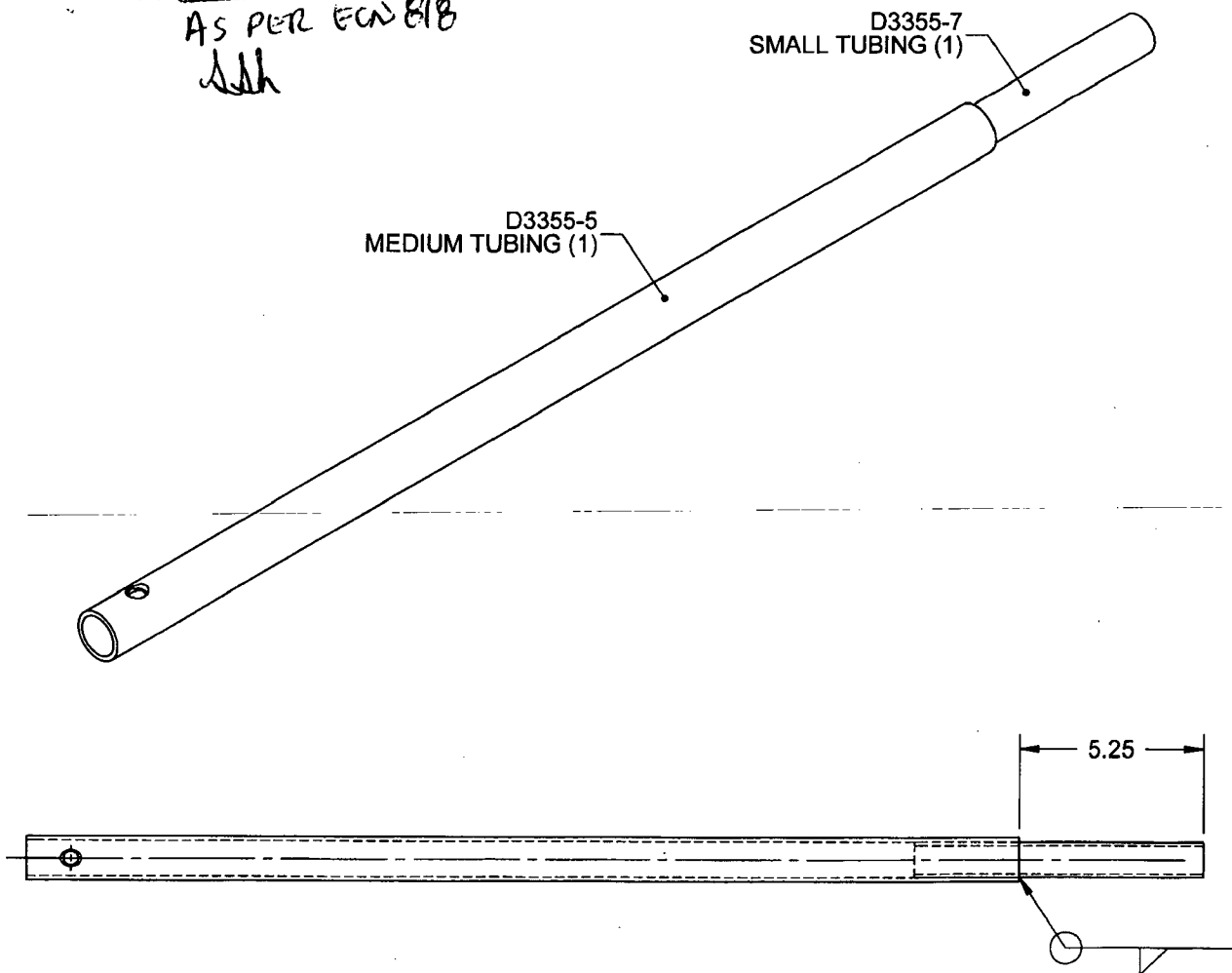


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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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SAH



D3355-047 ADJUSTABLE EXTENSION

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

B 44310

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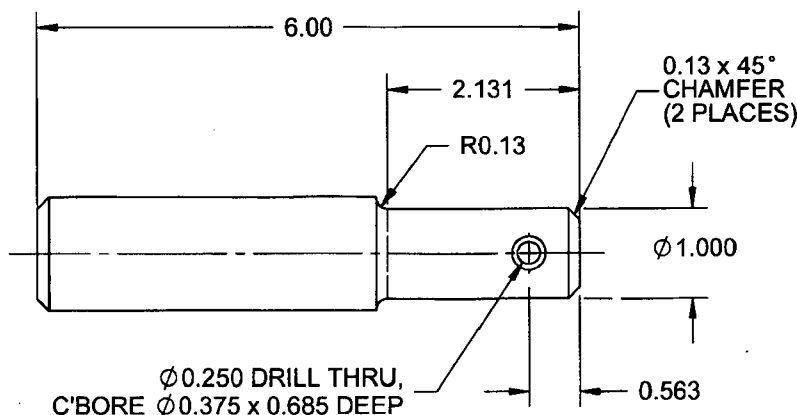
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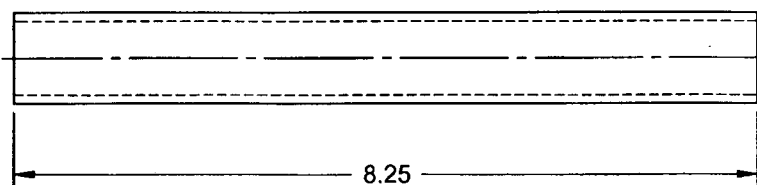


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D3355-1 PIN

D3355-1 NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



D3355-7 SMALL TUBING

D3355-7 NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

wp 44310

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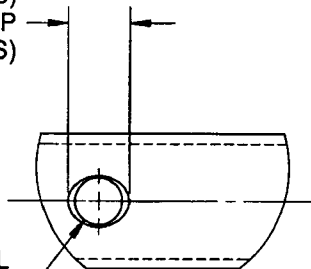
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:6

CHAMFER $\phi 0.687$ (11/16)
x 45°, 0.060 DEEP
(2 PLACES)

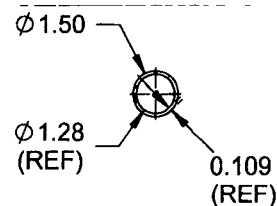
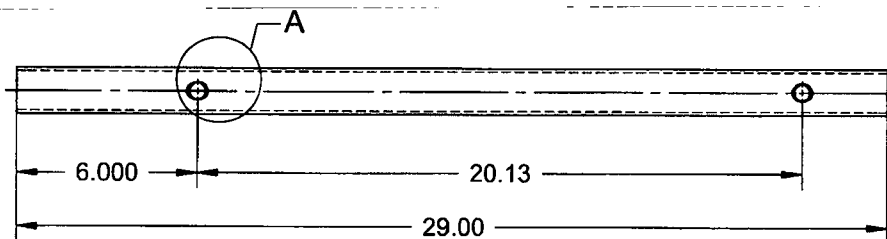
$\phi 0.531$ (17/32) DRILL
THRU (2 PLACES)



DETAIL A
SCALE 1 : 2

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06.06.21

AS PER ECN 818 *[Signature]*



D3355-3 LARGE TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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W/O:		WORK ORDER CHANGES							
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

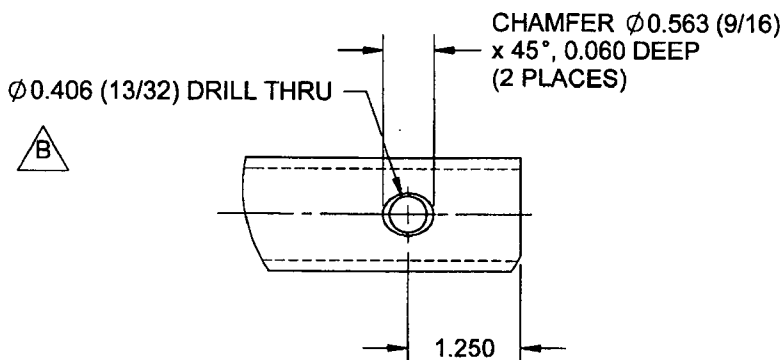
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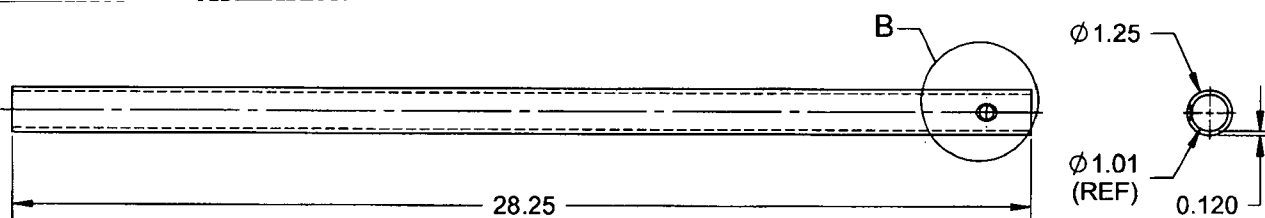


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DETAIL B
SCALE 1 : 2



D3355-5 MEDIUM TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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W/O 44310

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